

Work Order ID 151677

Wednesday, October 05, 2016 3:09:22 PM

Page 1

Item ID: 647.0410

Revision ID:

Item Name: Tube

Start Date: 9/30/2016 Start Qty: 5.00

Required Date: 10/24/2016 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

DAS

21

9-89

Date: OCT 06 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

647.0400

N/C

110

0.00

110

Small Fab

Memo

0.12

Small Fab

1- CUT AS PER DWG
2- DEBURR AS PER DWG

5

FF

OCT 06 2016

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

5

DAS
38
9-89

OCT 07 2016

151677647.0410
B151677
REF. N/C Accept***N900040100***

Setup

Start

NS1

Stop

NS2

Cust Item ID:

Customer:

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Work Order ID 151677

Wednesday, October 05, 2016 3:09:22 PM

151677

Page 2

Item ID: 647.0410 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tube
Start Date: 9/30/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 10/24/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
130									
Outsource4	Memo	149.99							DAS 13 9-89
Outsource process - Anodize	Issue P/O to ATG : <u>339/16</u>								
	1- Black Anodize as per Dwg 647.0400								
	2- PRIME AS PER DWG, SEE NOTE #2								
	Certification of Comformity is required								
140	Receive & Inspect for Damage & Mat'l Certs	0.00							
140									
Packaging	Memo	0.02							
Packaging									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.02							DAS 38 1-89
Quality Control									

NOV 01 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Work Order ID 151677

Wednesday, October 05, 2016 3:09:22 PM

151677

Page 3

Item ID: 647.0410

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tube

Start Date: 9/30/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 10/24/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: CC K107 0.00

180

Packaging

Memo

0.01

5

DAS
21
9-89

NOV 0 1 2016

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.08

DAS
21
9-89

NOV 0 2 2016

Quality Control

DAS
21
9-89

NOV 0 1 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Picklist Print

Page 1

Wednesday, October 05, 2016 3:09:21 PM

Work Order ID: 151677

151677

Parent Item: 647.0410

647 0410

Parent Item Name: Tube

Start Date: 9/30/2016

Required Date: 10/24/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.09.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.035		Purchased	No			110	f	30.0300	0.4275	2.25			
M6061T6T1 000W 035									**		FF OCT 06 2016		
6061-T6 ROUND TUBE 1" X .035" WALL													

LocationLoc QtyLoc Code

MAT015

30.03

124694

6.03

m135489

24

2.25

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

		647.D410	TUBE		A	A
		FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY		PARTS LIST				
NEXT ASSY (S)		APICAL INDUSTRIES				
646.9500		7608 TEMPLE HEIGHTS DR. OCEANSIDE CA. 92056-3512 (760)724-5300				
		TUBE				
		REV C NOV				
		SCALE NONE 1 SHEET 1 OF 2				

DART AEROSPACE LTD		Work Order:	151677
Description: Tube		Part Number:	647.0410
Inspection Dwg: 647.0400 Rev: N/C		Page 1 of 1	

[illegible]

Measured by:	FF	Checked by:	30 9-89	QC Inspector:	
Date:	OCT 06 2016	Date:	OCT 06 2016	Date:	

Engineering Approval: (If necessary)		Date:
---	--	-------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33916**

Purchase Order Date 10/12/2016

PO Print Date 10/19/2016

Page Number 6 of 7

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

VENDOR'S TRUCK

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

16 150286

647.0210 RAIL REV. N/C

10/28/2016

5.00

\$10.50

\$52.50

Yes

10/28/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total:

\$52.50

17 151677

647.0410 TUBE REV. N/C

10/28/2016

5.00

\$8.65

\$43.25

Yes

10/28/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total:

\$43.25

18 151467

647.1612 SPLICE PLATE
REV. A

10/28/2016

6.00

\$6.90

\$41.40

Yes

10/28/2016

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N

Line Total:

\$41.40

Note:

10/19/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912462

Date: 28-Oct-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20291 PO: 33916 Line: 14		
12 ea	Part: 647.0116 Doubler Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20292 PO: 33916 Line: 15	Rev: A	
5 ea	Part: 647.0210 Rail Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20293 PO: 33916 Line: 16	Rev: N/C	
5 ea	Part: 647.0410 ✓ Tube Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20294 PO: 33916 Line: 17	Rev: N/C <i>8/16-10-31</i>	
6 ea	Part: 647.1612 Splice plate Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20295 PO: 33916 Line: 18	Rev: A	
1 ea	Part: ADMINISTRATION FEE ADMINISTRATION FEE Job: 20296 PO: 33916 Line: 19	Rev: N/A	
10 ea	Part: 646.3012 Lower guide	Rev: N/C	



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912462

Date: 28-Oct-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

Quantity	Description
----------	-------------

ea	Gusset Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20285 PO: 33916 Line: 8
----	---

12 ea	Part: 646.3715 Rev: A Strur doubler Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20286 PO: 33916 Line: 9
----------	---

DATE: 28/10/16

CERTIFIED SIGNATURE: [Signature]

RECEIVER SIGNATURE: [Signature]

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.

MADE IN CANADA.